



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-547-043
Job Sheet 179747



Part No: D206-547-043

Job Qty: 2 ea

Part Name: Console High Slope



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D206-547 REV F IPP Rev:1 06-01-05 Removed Packing Kit JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	2 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Small Fab-1		DAS 58 18/19/18
100	Small Fab	2 pcs	7/18/18	7/18/18	0.00	2.14	Small Fab-1		9-89 DAS 68
110	Small Fab	2 pcs	7/18/18	7/18/18	0.00	2.14	Small Fab-1		SEP 21 2018 68
120	QC	2 pcs	7/18/18	7/18/18	0.00	0.00	QC5		9-89
130	Large Fab	2 pcs	7/18/18	7/18/18	0.00	1.43	Large Fab 8		1/3c 9-89
140	QC	2 pcs	7/18/18	7/18/18	0.00	0.00	QC5		EL
150	QC	2 pcs	7/18/18	7/18/18	0.00	0.00	QC10		EL
160	Small Fab	2 pcs	7/18/18	7/18/18	0.00	2.14	Small Fab-1		Sm 18/10/18
170	QC	2 pcs	7/18/18	7/18/18	0.00	0.00	QC5		38
180	Powdercoat	2 pcs	7/18/18	7/18/18	0.00	0.16	Powdercoat4		BL 18-10-18
190	QC	2 pcs	7/18/18	7/18/18	0.00	0.00	QC3		38
200	Packaging	2 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3-1		OCT 15 2018
210	QC21-FG	2 Ea	7/18/18	7/18/18	0.00	0.00	QC21		OCT 15 2018

Part Op 100 - 1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, Descriptions: DT 8264-2, DT8264-3, DT8264-4 2-Deburr

110 - 1-Grind weld relief chamfer as per Dwg D206-547 2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

130 - 1-Tack weld as per Dwg D206-547 A/R AL ROD Batch: 134785

160 - 1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

180 - START TIME: 7:45 OVEN TEMPERATURE: FINISH TIME: 8:15

1139839

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MS20470AD3-4	Rivet, Universal Head	40 Ea (20 ea)	90-Start up Operation	fr 134785 40
D2024	Extrusion (\$ Per Square Foot)	6.8400 Ea (3.42 ea)	110-Small Fab	f1-1
D2602-1	Console Side, 206 Console	2 Ea (1 ea)	110-Small Fab	5052371
D2602-2	Console Side, 206 Console	2 Ea (1 ea)	110-Small Fab	5057116
D2606	Console Bracket, 206/407 Console	2 Ea (1 ea)	110-Small Fab	5049924
D2607	Bracket, 206 Console	2 Ea (1 ea)	110-Small Fab	F9890
MS20470AD3-3	Rivet, Universal Head	16 Ea (8 ea)	110-Small Fab	F16941

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MS20470AD3-4	40	6,665	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

110-Small Fab

D2024	7	991	0
D2602-1	2	4	0
D2602-2	2	4	0
D2606	2	3	0
D2607	2	6	0
MS20470AD3-3	16	5,657	0

Part Specifications

Specifications could not be found.

Plex 6/21/18 7:49 AM Dart.lajeunesse.marie



Container No: S111656



Part: D206-547-043

Job No: 179747

Serial No/Batch: S111656

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.

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Canada

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Email: sales@dartaero.com

www.dartaerospace.com

Date: 09/19/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				